

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014933**Date Inspected:** 09-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China

<b>CWI Name:</b>	Mr.An Qing Xiang/zhao chen sun			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed

**Magnetic Particle Testing:-****Trail Assembly Area:-**

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as 65M Cross Bracing Gusset Plate. The weld designations reviewed are as follows:-

WD1-GUSA3-3-65M-S-3A/B,4A/B

WD1-GUSA3-3-65M-N-3A/B,4A/B

**Bay#11:-**

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as West Shaft Lift 3 BC,CD Corner capping plate at 111.67M elevation. The weld designations reviewed are as follows:-

WSTL3-4K/K-35,44

**IN PROCESS INSPECTION:-**

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## WELDING INSPECTION REPORT

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Trail Assembly Area:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SA164B/F-14 located on Doubler strut plate at 53M elevation. Welder is identified as 040582. ZPMC CWI is identified as Mr. Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4313-TC-P4.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: NSD1-SA166B/F-14 located on Doubler strut plate at 53M elevation. Welder is identified as 057220. ZPMC CWI is identified as Mr. Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-4313-TC-P4. Please see the attached picture.

Bay#11:-

This QA inspector observed the following work in progress:

SMAW Welding of weld joint no:-ED1-STSA4-6-131M-1-10A/B located on Strut Plate. Welder is identified as 044551. ZPMC QC is identified as Mr. Mao Mao Bin. Welding was been performed against temporary welding repair report T-WR3327 and UT report number- T787-UT-2933. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G(2F)-FCM-Repair-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ESD1-SPSA5-7-1A located on Lift 5 Interior Splice Plate. Welder is identified as 046709. ZPMC QC is identified as Mr. Xu jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSD1-SPSA5-2-1A located on Lift 5 Interior Splice Plate. Welder is identified as 046769. ZPMC QC is identified as Mr. Xu jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

Bay#10:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SPSA5-16-2B located on Lift 5 Interior Splice Plate. Welder is identified as 050289. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SSD1-SPSA5-19-1A located on Lift 5 Interior Splice Plate. Welder is identified as 052930. ZPMC QC is identified as Mr. Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-3211-TC-U5b-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No Relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mr.Micheal Ng- 159-2184-5703, who represents the Office of Structural Materials for your project.

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**Inspected By:** Pillai,Pandaram

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer